

## ABSTRACT OF THE DISCLOSURE

A planetary gear motor assembly opens and closes a shutter door on a coin dispensing mechanism. The assembly includes a cage having a pair of annular plates with a plurality of cluster gears composed of upper and lower planet gears sandwiched between the pairs of annular plates. The improvement is a plurality of pins on which the cluster gears are placed. Each of the pins is staked at opposite ends to the pair of annular plates so that structural integrity of the assembled cage is retained during rotation and abrupt stopping of the planet gears. A method of manufacturing a planetary gear motor assembly for opening and closing a shutter door on a coin dispensing mechanism includes several steps. Initially, there is assembled a cage having a pair of annular plates with a plurality of cluster gears composed of upper and lower planet gears sandwiched between the pair of annular plates. The improvement is a step of staking a plurality of pins, on which the cluster gears are placed, at opposite ends to the pair of annular plates, whereby structural integrity of the cage is retained during rotation and abrupt stopping of the planet gears.